

Work Order ID 51759

September 2, 2009 10:16:55 AM



Page 1

Item ID: D350-636-012

Accept



Setup Start



Revision ID: F

Item Name: Skidtube RH

Stop



Start Date: 09/02/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/28/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-09-02 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2750	Rev F

100 0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 004

S 09/10/09

110 0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end □2-Drill pilot holes as per Dwg D2750 sheet 5 (D2750-2 details). Drill using drill Jig DT8150 & DT8863. □3- Mark fwd end for cutting using Drill Jig

11/11/99

86 09/10/09

120 0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

2/8 09/10/09

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

2802/11/20



Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 Ø - AUM 9-10-20

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 Ø BE 9-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750. 3-Open float holes to .500" (4 per Side) 4-Chamfer holes of Detail								
	<i>A/R M111999 BE 09/10/21</i>								
170 	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	Memo	0.00							
Quality Control									
180 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

SEE ATTACHED SHEET - D

2) 509/10/23



2) 509/10/23



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

REFERENCE ONLY

B-51759

REFERENCE ONLY

See 160

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side)

as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291 batch: M112 391 AWM-9-10-20
exp. date: ~~9-10-20~~ 10-02-20

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004

(welding instructions on sheet 9)

A/R Aluminum Rod batch: M111999 SE 9-10-21

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750

11- At section AJ-AJ drill out x-bolt spacer to 0.404"

12-Deburr holes AWM 9-10-21

REFERENCE ONLY

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Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 ⇒ <i>Jul</i> 0.00	<i>09/10/26</i>			<i>(X1)</i>	<i>Ø</i>		
200 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: <i>10:30am</i> □ OVEN TEMPERATURE: <i>11:00am</i> □ FINISH TIME: <i>3:20pm</i>	0.00 <i>M112260</i> 0.00 <i>⇒ Jul 09/10/26</i>				<i>(X1)</i>	<i>Ø</i>		
210 QC Quality Control	QC3- Inspect Part Finish Memo Inspect for foreign object per QSI 024	0.00 <i>UMP</i> 0.00	<i>09/10/28</i>			<i>X1</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Page 5

Accept

Setup Start

Stop

11-11-11

Cust Item ID:

Customer:

Run Start

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

**Draw
Number**

**Draw
Rev.**

**Plan
Code**

Accept
Qty

Reject
QtyReject
Number

**Insp.
Stamp**

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

Install inserts as per dwg D2750

0.00

[illegible]

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Inspect for Foreign Objects ☐ 2-Spray inside of tube with "LPS-3"

batch: u/a ☐ 3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241 ☐ BATCH: m 112391 ☐ EXP DATE: 10/20 ☐ 4-

LPS PROCYON: BATCH: m104251

0.00

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/10/09

DS

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

2) 80% sub

ⓧ

/

270

Packaging

Loc 72 Reug

0.00



Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-012

9/10/09

DS

51759

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/02

W 9.10.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

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Work Order ID: 54759

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH



Comments:

Start Date: 09/02/2009

Required Date: 09/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-225		Purchased	No			230	Each	8,787.000	38.0000			
												

Insert

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

8787

107441

16

110768

8771

AN3C5A

Purchased

No

230

Each

646.0000

34.0000



Bolt



X38 MD 09/10/28

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

646

111424

8

111707

338

112314

200

112489

100

AN3C6A

Purchased

No

230

Each

1,048.000

4.0000



BOLT



X34 MD 09/10/28

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

1048

110372

72

11982

976

X4 MD 09/10/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 51759



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH



Start Date: 09/02/2009

Required Date: 09/28/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN6C44A  BOLT		Purchased	No			230	Each	172.0000	4.0000 			

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

2

103964

2

Main Warehouse

ST

170

110105

4

110155

14

110665

1

110865

51

111605

50

111649

50

112720

x4 mo 09/10/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 54759

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH



Comments:

Start Date: 09/02/2009

Required Date: 09/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN8C21A  BOLT		Purchased	No			260	Each	112.0000	2.0000 		9/10/08	SP

Warehouse
Location

Main Warehouse

ST	Loc Qty
105160	1
107596	1
107924	2
109092	2
110341	2
110342	4
111605	50
111684	50

AN8C35A



BOLT

Purchased

No

230

Each

167.0000

1.0000


Warehouse
Location

Main Warehouse

ST	Loc Qty
102180	1
106896	1
110105	65
110847	100

XI MD 09/12/28

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

Work Order ID: 51759

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 09/02/2009

Required Date: 09/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			230	Each	2,500.000	38.0000			

Warehouse Loc Qty Loc Code

Location

OFFSHORE

112612

X38 MD 09/10/28

FG

100

103585

100

Main Warehouse

FP

-44

112116

-44

Main Warehouse

ST

2444

112116

2444

AN960C816L

Purchased

No

230

Each

330.0000

1.0000



WASHER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

330

104093

2

107520

4

110139

29

110372

36

110584

100

111424

159

X1 MD 09/10/28

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Parent Item Name: Skidtube RH

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Required Date: 09/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C816L WASHER		Purchased	No			260	Each	330.0000	2.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	330
104093	2
107520	4
110139	29
110372	36
110584	100
111424	159

D2600-3-BENTRevD1 Extrusion Bent		Manufactured	No			110	Each	0.0000	1.0000			
D2739RevD 350 I Beam		Manufactured	No			160	Each	6.0000	1.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG	4
50353	4
Main Warehouse	
ST	2
47124	1
47681	1

9/10/08 SP

2 SP

B 52346 BE 09/10/19

B-5230 5 MUM 9-10-20

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Work Order ID: 54759

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH



Comments:

Start Date: 09/02/2009

Required Date: 09/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2741RevC  Blade, 350 Skidtube		Manufactured	No			260	Each	40.0000	1.0000 		9/10/08	SP

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

40

20770

0

45320

1

47115

39

D2743RevB



Crossbolt Spacer

Manufactured

No

220

Each

294.0000

8.0000


1 SP

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

LG

50

50281

50

Main Warehouse

ST

244

44891

2

45555

177

48275

65

8 BE 09-10-01

September 2, 2009 10:16:54 AM

Shop Packet Print

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D2744RevC  Cap		Manufactured	No			160	Each	50.0000	1.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	50
44892	15
47488	35

D2745RevB



Bushing

Manufactured No

230 Each 272.0000 8.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	272
34817	2
36230	8
37303	1
39587	2
40726	2
41114	2
42778	19
43754	2
44893	37
45556	69
46695	18
48278	110

BE 09/10/19

MP 09/10/20

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 8

Work Order ID: 51759

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 09/02/2009

Required Date: 09/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3488-042RevB		Manufactured	No			230	Each	9.0000	1.0000			
Blade Fitting Assembly, RH												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

29043

44531

9

1

8

160

Each

165.0000

4.0000

xl mo 09/10/28

D3490-1RevA

Manufactured

No

Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

45338

47118

47657

48277

165

2

4

50

109

4 SE 09-10-21

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 51759

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 09/02/2009

Required Date: 09/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3490-3RevA  Cross Bolt Spacer		Manufactured	No			160	Each	112.0000	4.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	112	
45560	22	
47471	35	
48276	55	

D3492-041RevC Manufactured No

Plug Assembly

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	3	
43816	3	

D3492-043RevC Manufactured No

Plug Assembly

51584

52309

4 BE 09/10/21

x8 MD 09/10/28

x8 MD 09/10/28

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 10

Work Order ID: 51759

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 09/02/2009

Required Date: 09/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3493-1RevA Washer		Manufactured	No			260	Each	115.0000	2.0000		9/10/08	SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	115	
44902	15	
47710	100	

D3532-1RevA Spacer		Manufactured	No			110	Each	43.0000	2.0000		52321 9/10/08	SP
-----------------------	--	--------------	----	--	--	-----	------	---------	--------	--	---------------	----

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	43	
38161	2	
44904	41	

D3535-25RevB Wearshoe		Manufactured	No			230	Each	11.0000	1.0000			
--------------------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	11	
47523	11	
51663		

x1 MD 09/1/027

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 51759

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 09/02/2009

Required Date: 09/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-25RevA		Manufactured	No			230	Each	21.0000	1.0000			
												
Gasket												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse	51607	
ST	21	
45569	1	
47011	2	
47526	8	
50266	10	

x1 m009/10/28

D3537-1RevC

Manufactured No

230

Each

46.0000

3.0000



Wearpad

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	46	
48288	3	
50321	43	

51624

x3 m009/10/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 51759

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 09/02/2009

Required Date: 09/28/2009


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3631-1RevA  Washer		Manufactured	No			230	Each	105.0000	8.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	51908	
ST	105	
38139	6	
45353	16	
47437	83	

X8 MD 09/10/28

D3791-1RevA  Wearplate		Manufactured	No			230	Each	18.0000	1.0000			
--	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	18	
47536	8	
50269	10	
51610		

21 MD 09/10/28

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51759



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH


Start Date: 09/02/2009

Required Date: 09/28/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-1RevA  Wearshoe		Manufactured	No			230	Each	18.0000	1.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	5900	
ST	18	
40551	1	
47537	4	
50231	13	

21 mo 09/16/28

D3793-3RevA  Wearshoe		Manufactured	No			230	Each	22.0000	1.0000			
---	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	22	
47720	11	
50216	11	

21 mo 09/10/28

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51759

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 09/02/2009

Required Date: 09/28/2009


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3794-1RevA  Gasket		Manufactured	No			230	Each	7.0000	1.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	516608	
ST	7	
46530	1	
47212	2	
47721	4	

X1 MD 09/10/28

D3794-3RevA  Gasket		Manufactured	No			230	Each	27.0000	1.0000			
---	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	27	
46531	2	
47440	2	
47722	11	
50240	12	

X1 MD 09/10/28

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51759



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 09/02/2009

Required Date: 09/28/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-6 		Purchased	No			230	Each	1,132.000	4.0000			

NUT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1132	
110584	34	
111424	98	
112314	1000	

14 mo 09/10/28

MS21083C8



Purchased

No

230

Each

92.0000

1.0000



NUT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	92	
110584	5	
111424	2	
11163	21	
112243	44	
112492	20	

11 mo 09/10/28

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51759

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 09/02/2009

Required Date: 09/28/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21083C8

Purchased

No

260

Each

92.0000

2.0000



NUT

9/10/08 scf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

92

110584

5

111424

2

111637

21

112243

44

112492

20

NAS1515H3L

Purchased

No

260

Each

350.0000

4.0000



WASHER

2 scf

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

40

102472

40

Main Warehouse

ST

310

110450

2

110806

8

111819

300

24 MD 09/10/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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September, 2, 2009 10:16:54 AM

Work Order ID: 51759



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 09/02/2009

Required Date: 09/28/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS1515H8L

Purchased

No

260

Each

129.0000

2.0000



WASHER

9/10/08 sup

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

129

107581

34

108964

1

111650

94

2

NAS1611-010

Purchased

No

230

Each

345.0000

8.0000



O-RING

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

345

110715

50

110915

295

770

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W/O: 51759

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-09-28		Replaced O-ring NAS1611-010 for O-ring D2594-3 Batch: 51613 x 7 <u>52562 x 1</u>	MD	09-10-28	18		S 09/10/28

Part No: D350-636-012 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 51759



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH



Start Date: 09/02/2009

Required Date: 09/28/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1611-013  O-RING		Purchased	No			230	Each	320.0000	8.0000 			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

320

106513

11

111424

109

11758

200

X8 MD 09/10/28

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

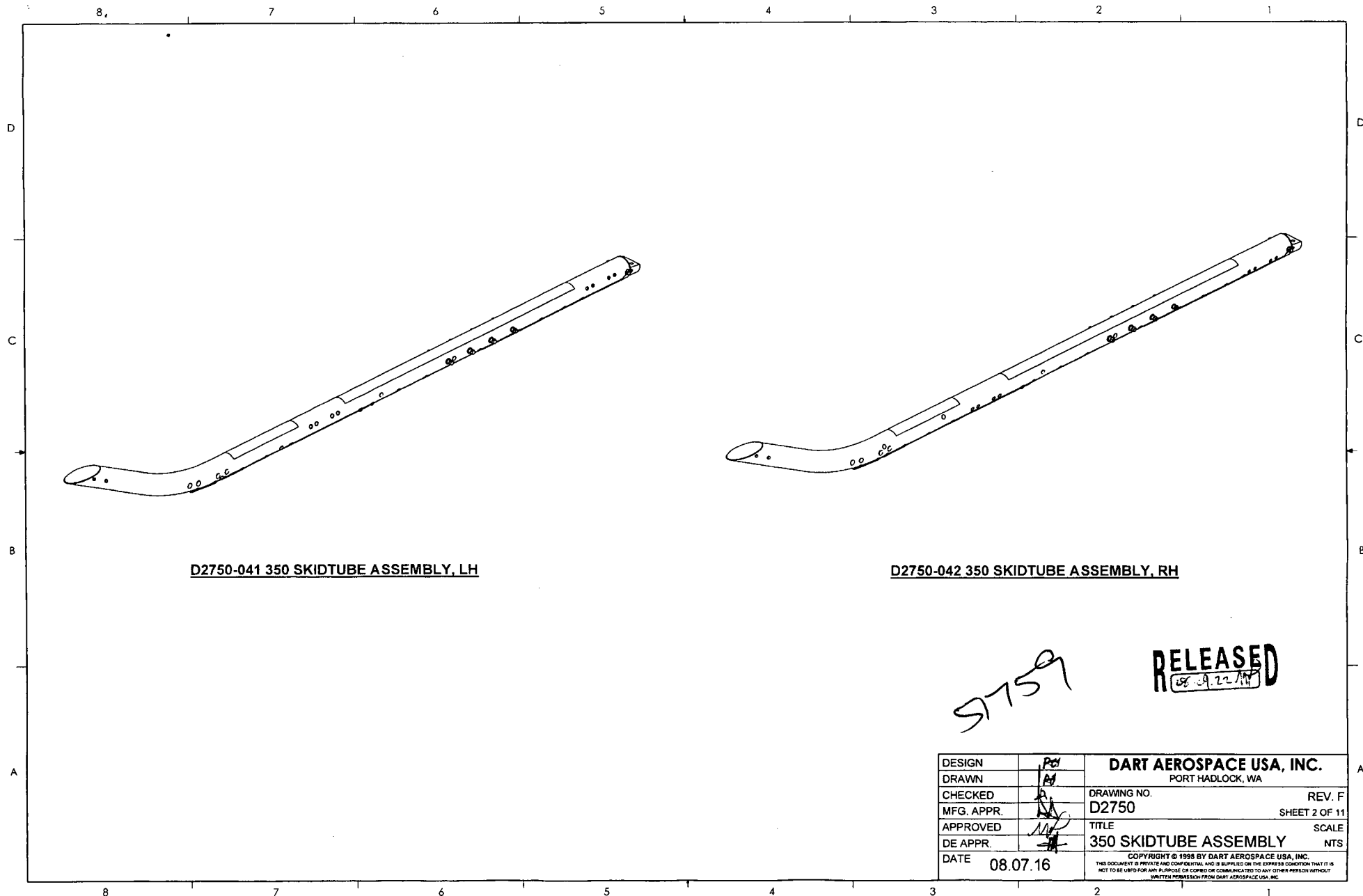
GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WITHOUT NOTICE
WORK ORDER
NO. 51759 WF 09-09-02

RELEASED
09-09-02

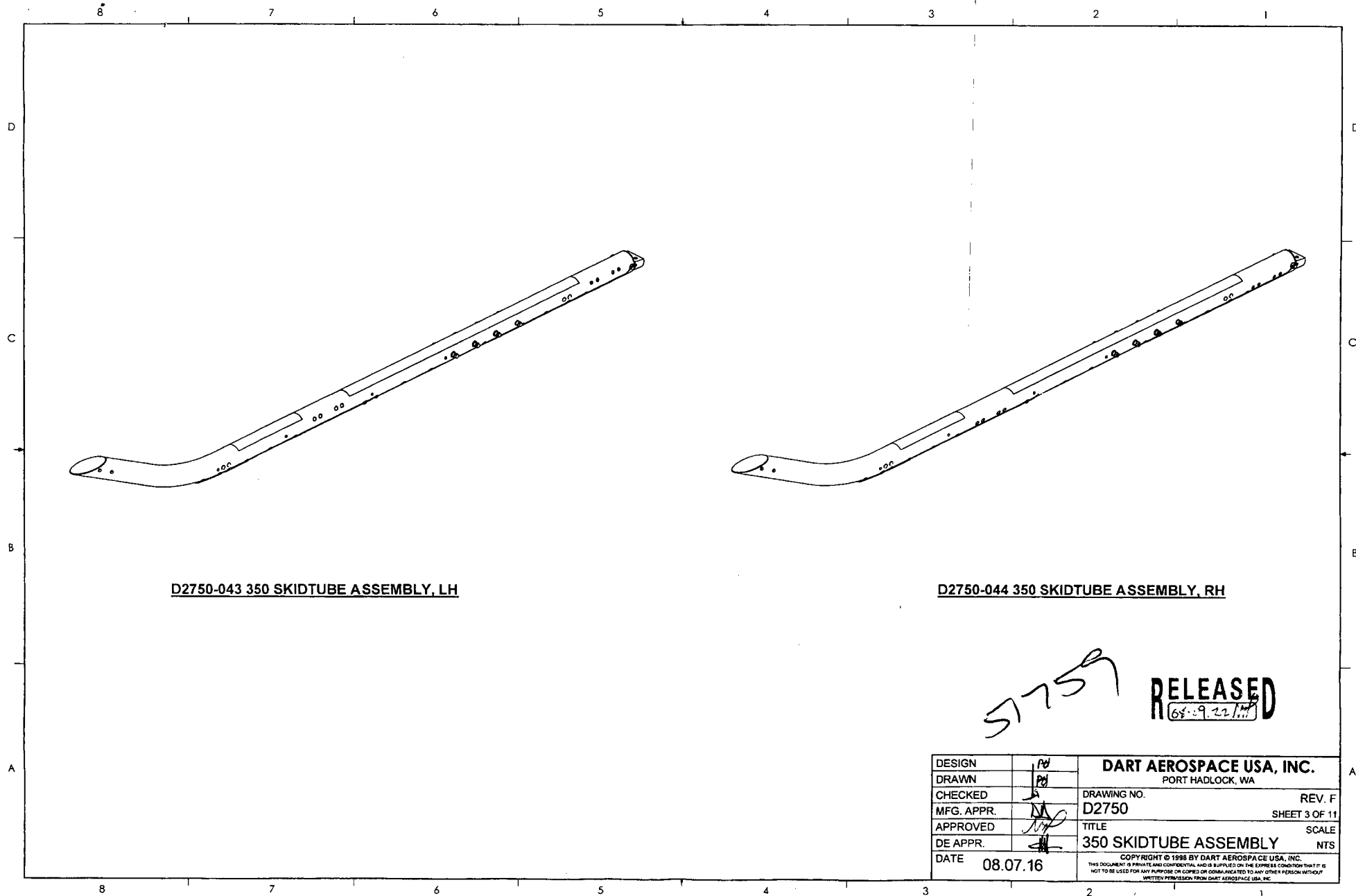
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3536-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PC	DART AEROSPACE USA, INC.	
DRAWN	PC	PORT HADLOCK, WA	
CHECKED	PC	DRAWING NO.	REV. F
MFG. APPR.	PC	D2750	SHEET 1 OF 11
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	350 SKIDTUBE ASSEMBLY	NTS
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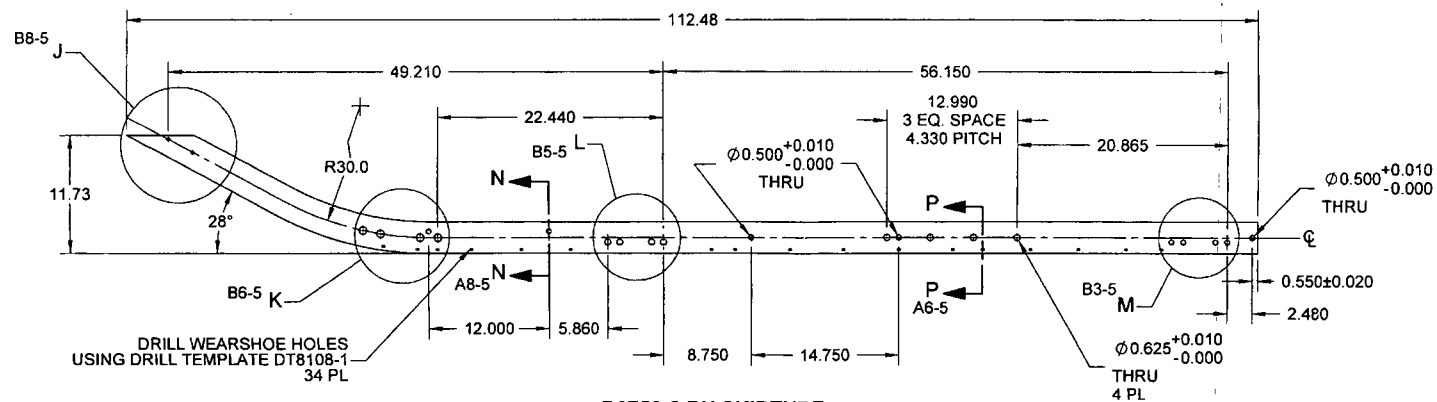


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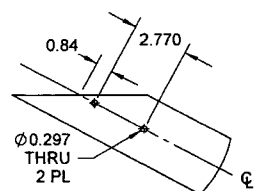
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158-09-22-14

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CHECKED	AM	DRAWING NO.	REV. F
MFG. APPR.	AM	D2750	SHEET 2 OF 11
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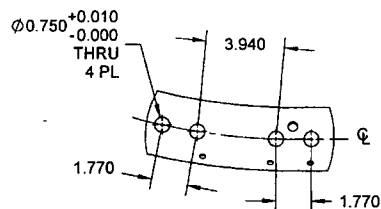




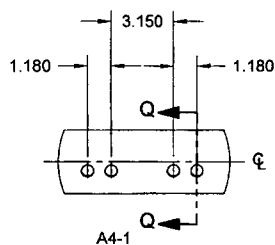
D2750-2 RH SKIDTUBE



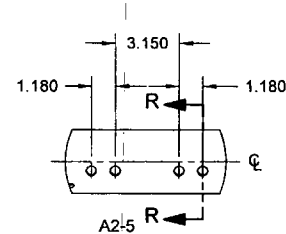
DETAIL J
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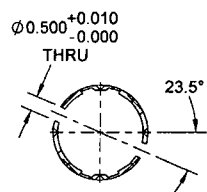
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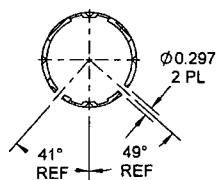
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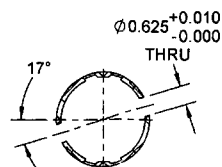
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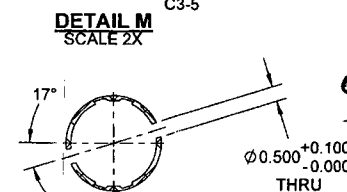
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL

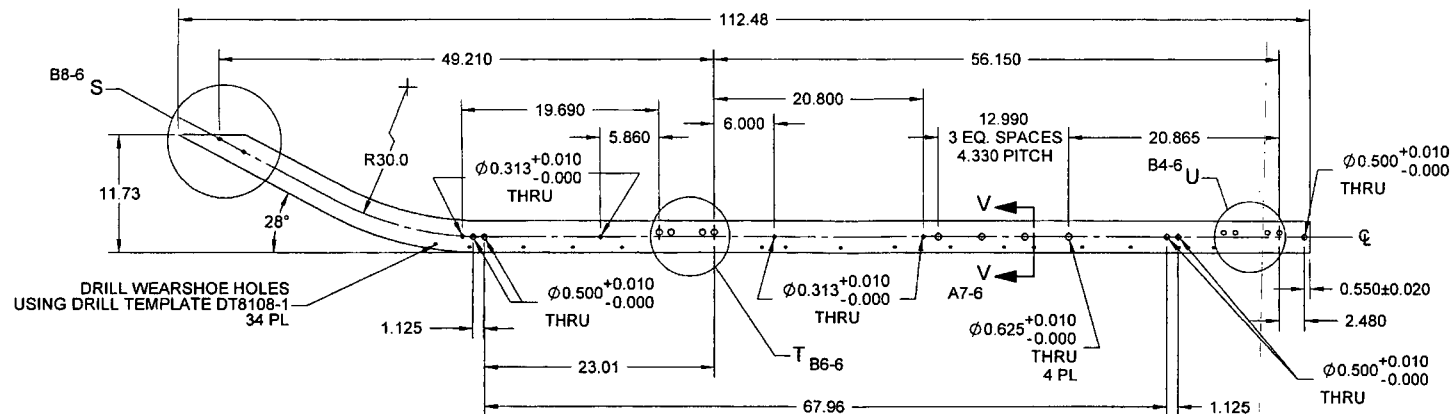


SECTION R-R
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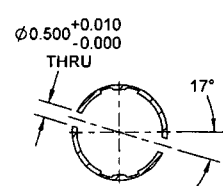
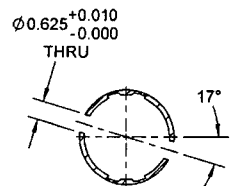
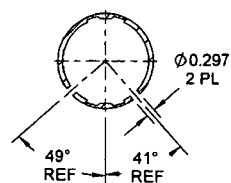
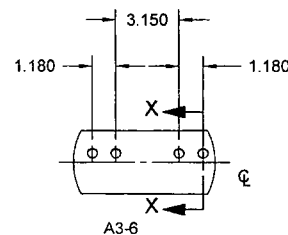
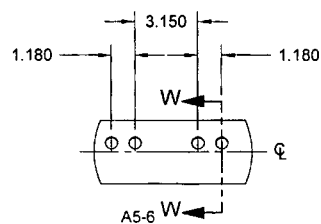
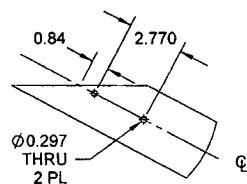
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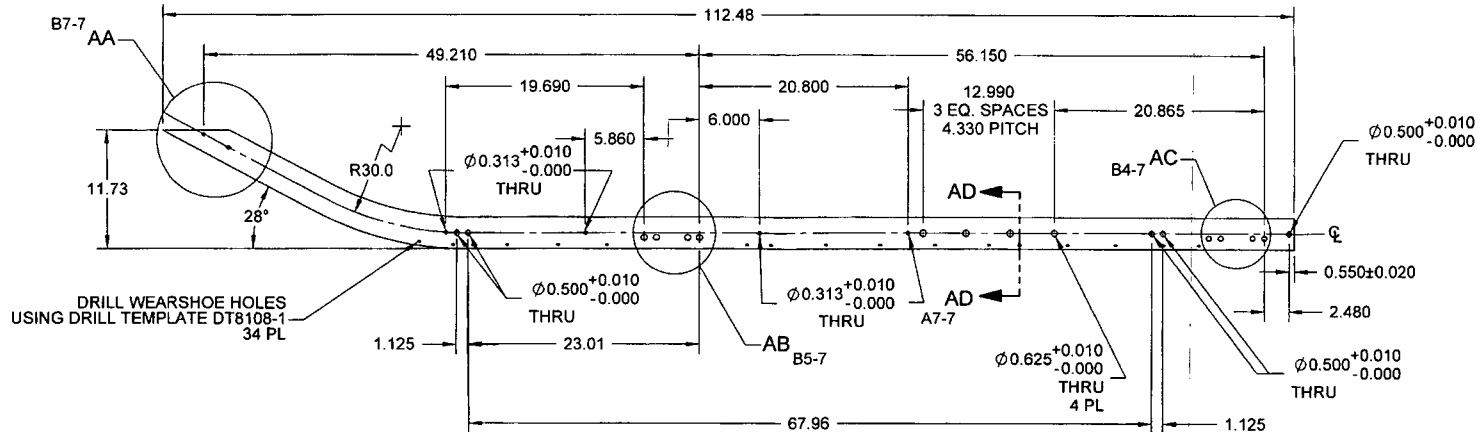


D2750-3 LH SKIDTUBE

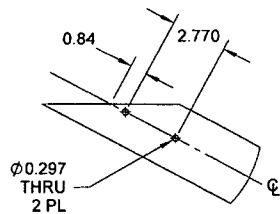


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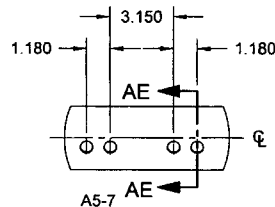
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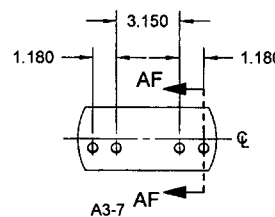
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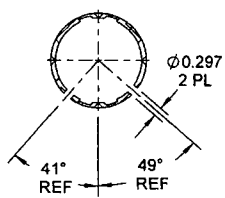
DETAIL AA
SCALE 2X



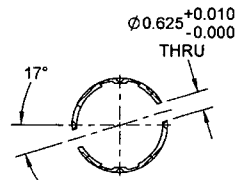
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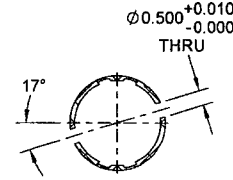
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



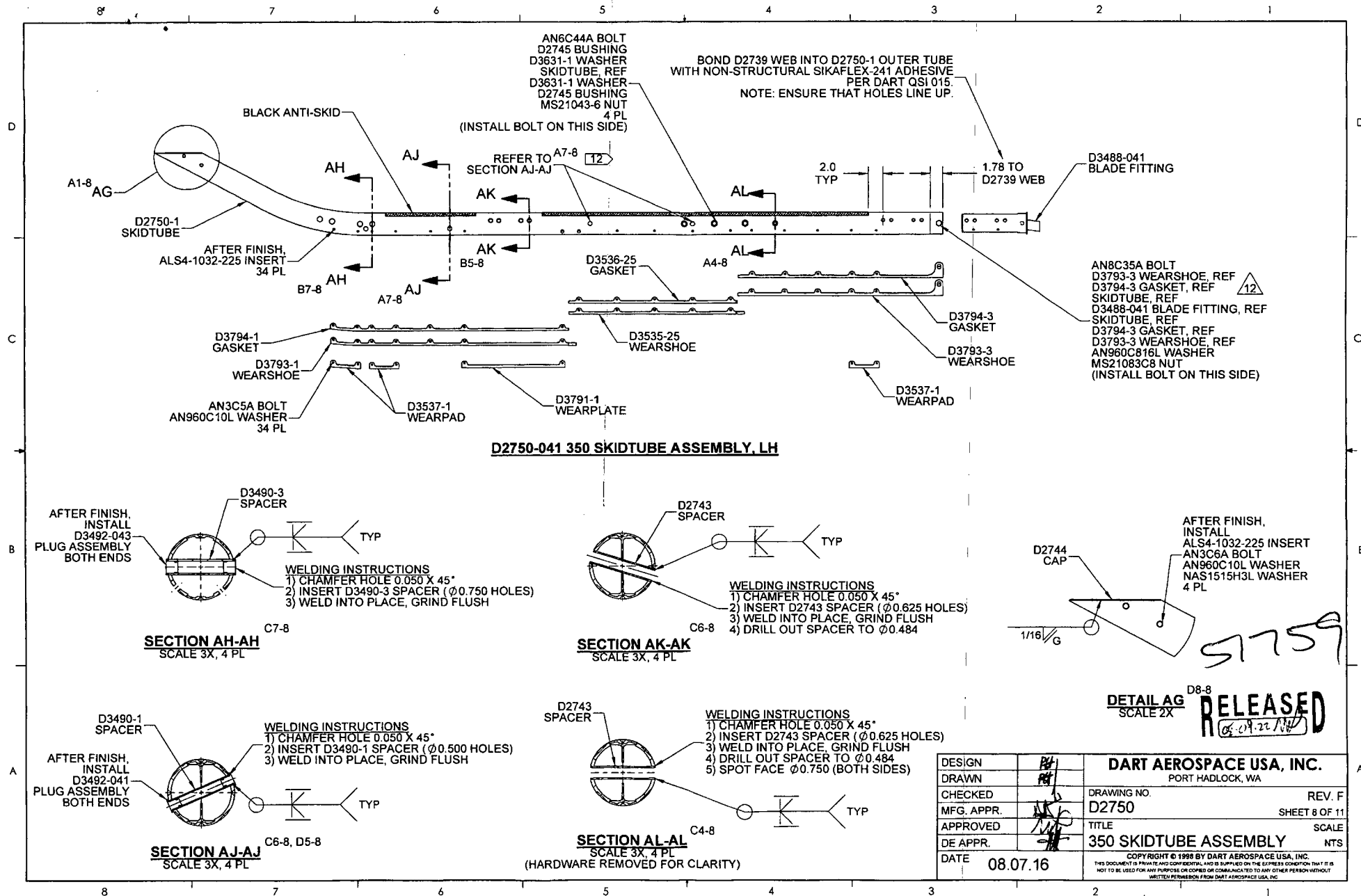
SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

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08-04-22-716

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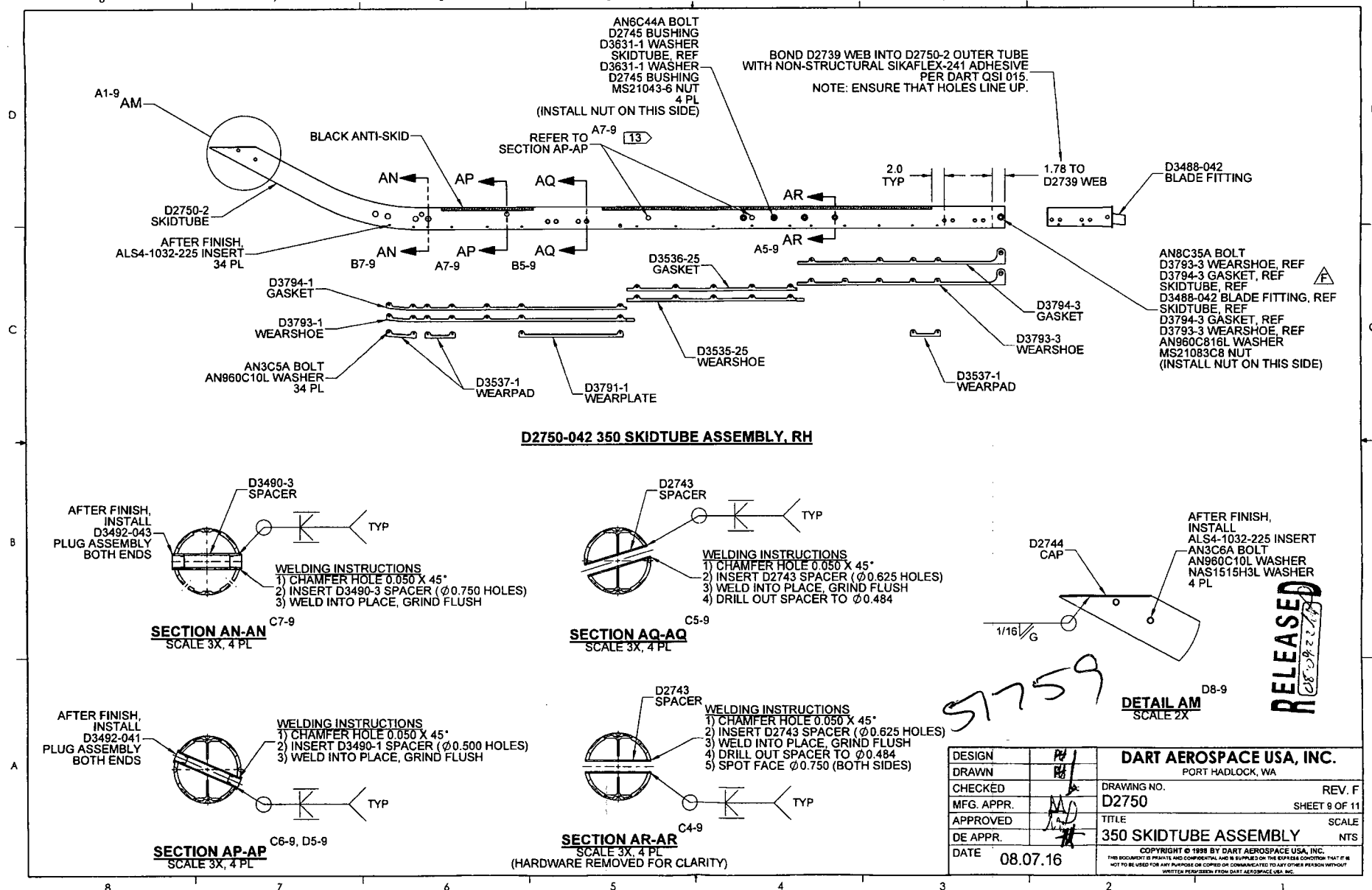
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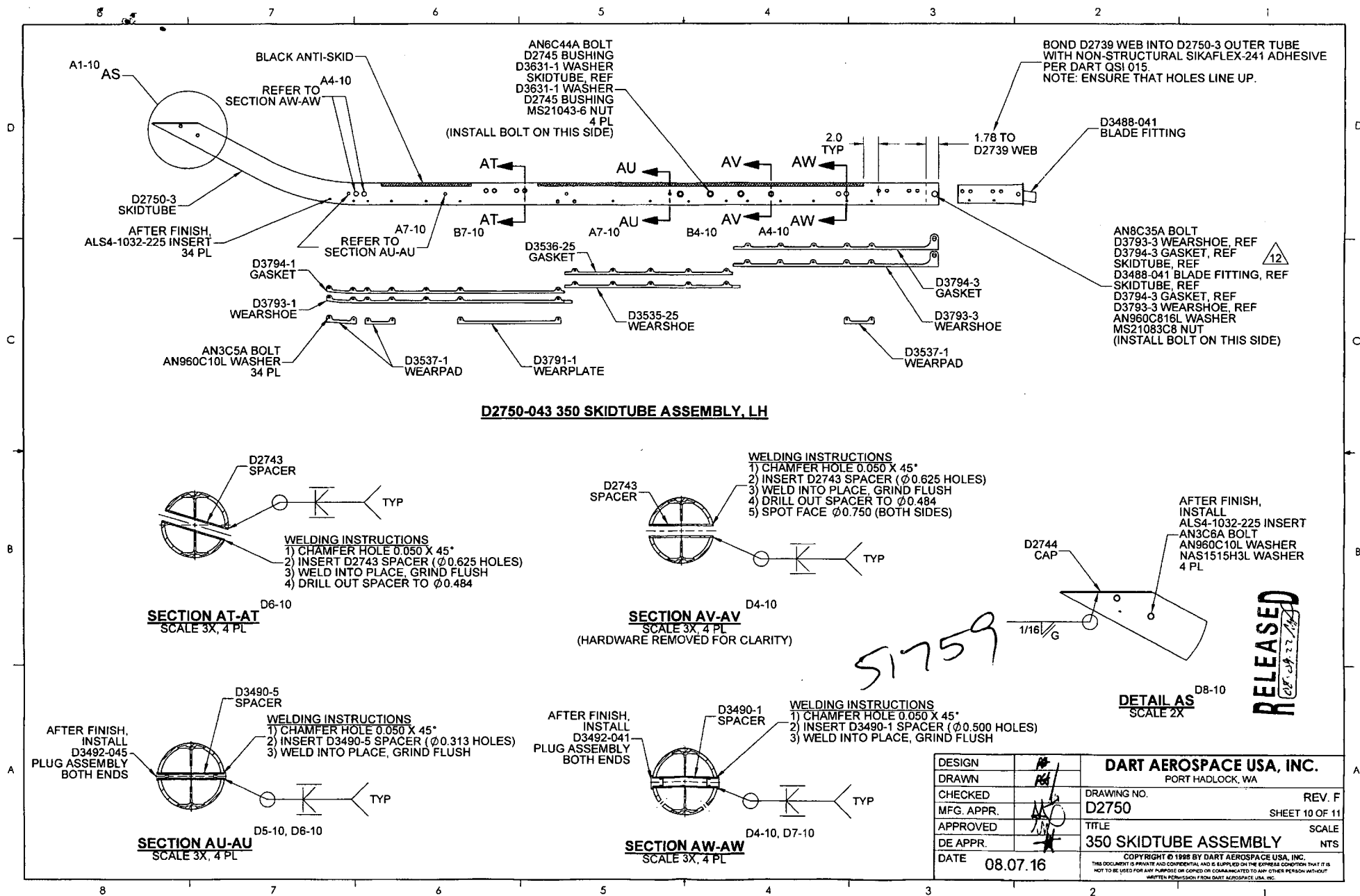
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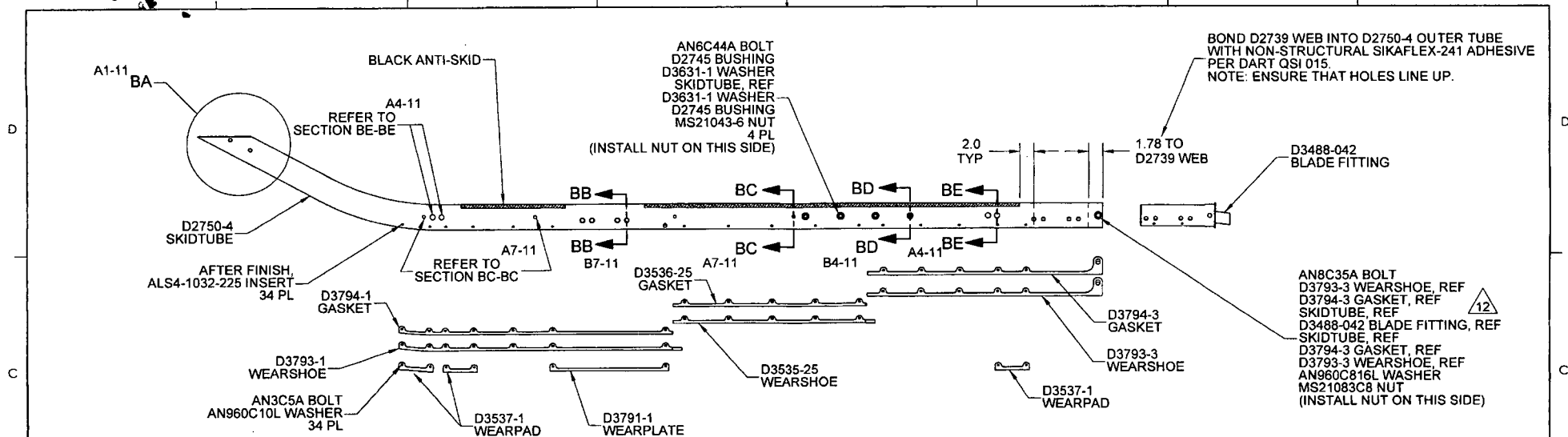
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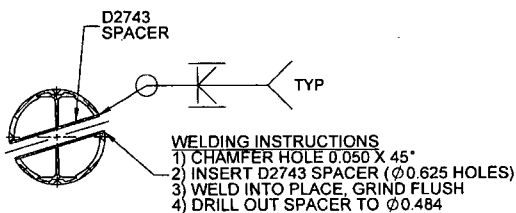
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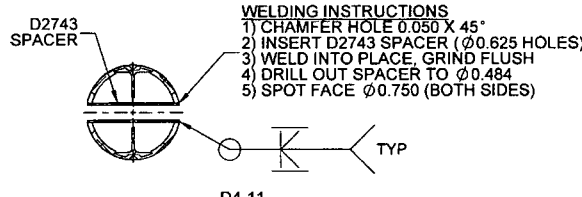


D2750-044 350 SKIDTUBE ASSEMBLY, RH

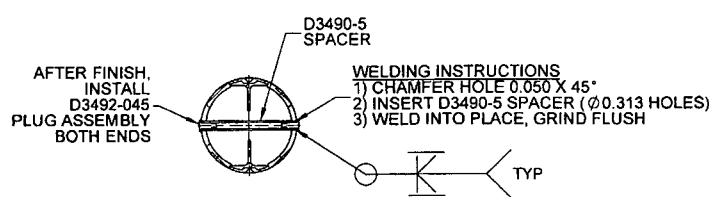
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06-07-22 / MP



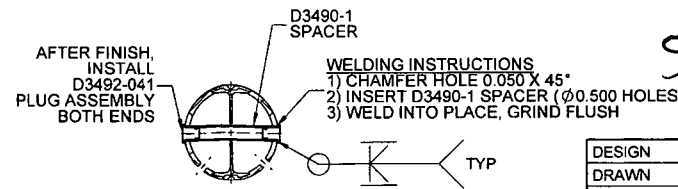
SECTION BB-BB SCALE 3X, 4 PL



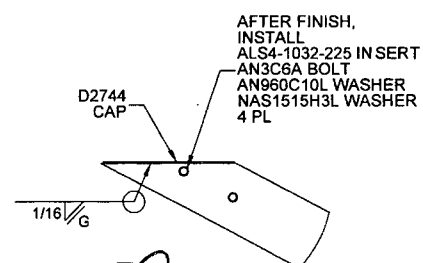
SECTION BD-BD SCALE 3X, 4 PL (HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC SCALE 3X, 4 PL



SECTION BE-BE SCALE 3X, 4 PL



DETAIL BA SCALE 2X

DESIGN	HA	DART AEROSPACE USA, INC.	
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8 7 6 5 4 3 2 1

NO. 213

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: B51620
Part number: 1350-636-Q12
Description: 350 SKID tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Said Said Date of Test Coupon 09/10/22
Welder Barclay Elliott Date of Test Coupon 09/10/22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld